

Date: Friday, 5/25/2007 8:36:36 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GAS SPRING - UNDER REVIEW
Job Number	: 32644		
Estimate Number	: 12702		
P.O. Number	: N/A	Part Number	: D35527
This Issue	: 5/25/2007	Drawing Number	: D3552 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 31149	Material	: N/A
Written By	:	Due Date	: 6/6/2007
Checked & Approved By	: <u>[Signature]</u> 07.05.25	Qty:	50
Comment	: Est Rev:A New Issue 06-11-13 EC	Um:	Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: Issue P/O: 3839

Purchase Part Number: B8-220-530-70N

Supplier: LS Technologies B6-220-530-070N

Certificate of conformity is required

07.05.28

20
50

only

P.T.O

07.06.01

2.0 B822053070N CARBON STEEL GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

CARBON STEEL GAS SPRING

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

07.06.19 50

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Test for correct pressure

07.06.21

50

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07.06.22 50

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.06.01	1-0	change gas spring PIN to B6-220-530-070N on request from supplier - acceptable	LE	07.06.01	50	LE 07.06.01		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 15 Date: 07/06/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.06.01	1-0							

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:36:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING - UNDER REVIEW

Job Number: 32644

Part Number: D35527

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



50

Comment: FINAL INSPECTION/W/O RELEASE

120716125

Job Completion



120716125

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



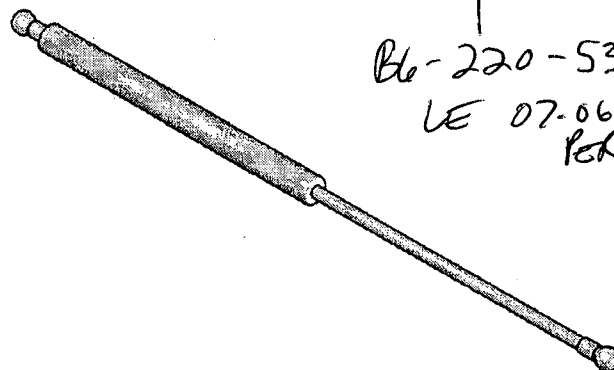
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3552	REV. B SHEET 1 OF 1
DATE 06.09.15		TITLE GAS SPRING SCALE 1:1	
REV	DATE	DESCRIPTION	
A	06.09.15	NEW ISSUE	
B	06.10.24	ADD D-3552-7/-9; UPDATE DESC. D3552-1/-3/-5	

SPECIFICATION CONTROL DRAWING

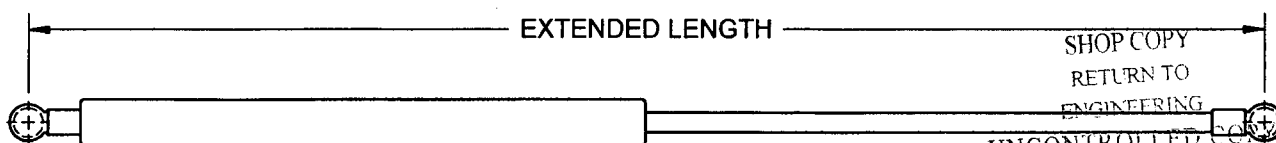
UNDER REVIEW

01.02.2015
ADD D-3552-7/-9

DART P/N	STROKE (mm)	EXTENDED LENGTH (mm)	FORCE (N)	END FITTING	MATERIAL	LS TECHNOLOGIES P/N
D3552-1	220	530	70	10 mm SS BALL SOCKET	CARBON STEEL	C8-220-530-70N
D3552-3	200	490	200	10 mm SS BALL SOCKET	CARBON STEEL	C8-200-490-200N
D3552-5	175	430	150	10 mm SS BALL SOCKET	CARBON STEEL	C8-175-430-150N
D3552-7	220	530	70	10 mm NYLON BALL SOCKET	CARBON STEEL	B8-220-530-70N
D3552-9	200	490	200	10 mm NYLON BALL SOCKET	CARBON STEEL	B8-200-490-200N



B6-220-530-070N
LE 07-06-21
Per 651842



D3552-X GAS SPRING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *32644*

RELEASED
06.12.22

COPYRIGHT © 2006 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



P.O. Box 25032, Saskatoon, Saskatchewan, Canada S7K 8B7

Ph: (306) 683-5000 Fax: (306) 683-6403

E-mail: lstech@lstechnologies.ca www.liftsupporttechnologies.com

Certificate of Compliance

This is to certify that the merchandise listed below meets specifications as required by your order.

50 Units: B6-220-530-070N CARBON STEEL GAS SPRING

This product is ROHS compliant

We certify no mercury was used in the manufacture of this order.

Order # PO00003839

LS Technologies Inv # 3750



L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read "Nolan Fehr".

Nolan Fehr

LS Technologies Canada Inc.

Box 25032

Saskatoon, SK

S7K 8B7

Packing Slip

Date	Packing Slip #
6/13/2007	3750

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

Ship To
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

Order No.	Rep	Ship Date	Ship Via
3839	Nolan	6/13/2007	Purolator

Qty	Description
50	B6-220-530-070N Carbon Steel Gas Spring Shipping and Handling PUROLATOR / DHL - Tracking #320365382656 Total GST Business Number: 875007718

EP 6/13/07

Please remit to above address. Thank you for the business.